June-07-12 9:20	0:48 AM		*85381*					Page 1		
Item ID: Revision ID:	D412-698-038	A	ccept	*N900040	1100*	Setup St	art *N	S1*		
Item Name:	Bracket Assembly, RH (Composit	te Doors)				Si	op * N	S2*		
Start Date: Required Date: Reference:	07/06/2012 Start Qty: 1.0 21/06/2012 Req'd Qty: 1.0			Cust Item ID: Customer:						
Approvais:	Process Plan: _MLJ QC:	Date: 17/06/07 Date:	Tooling: SPC (Y/N):	Date:	151 - 21		art *N op *N	R1* R2*		
Sequence ID/ Work Center II	Operation Description	1.0 (2022)	Set Up/ Run Hours	Tool ID Tool #	Flan Acc Code Qty			Insp.		
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DSI 9484	С									
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110	Pick Kit		0.00							
110 Packaging Packaging	Memo		0.00			1		12/06/27 ₀		
*120	QC4- 100% Inspect	kits for completeness	0.00	t ps)				
QC	Memo	•	0.00		L.C.	/				

Quality Control

-air rioi copaço Ela	Dart	Aeros	pace	Ltd
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W/O:	WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									-	
				ĝe.						
Part No	•	PAR #:		197	NCR: Yes	No DQ	A:	Date: _		
	Res	olution:	QA: N/C (Closed:	· · · · · · · · · · · · · · · · · · ·	Date: _				
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NC	R)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	ction B Sign Date	& Sec	cation tion C	Approval Chief Eng	Approval QC Inspector		
							<u></u>			
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					4			:		
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NOTE: Date & initial all entries

Page 2

June-07-12 9:20:48 AM

Required Date: 21/06/2012

Item ID:

D412-698-038

Accept

N900040100

Setup Start

Revision ID:

Item Name: **Start Date:**

Bracket Assembly, RH (Composite Doors)

07/06/2012

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:____

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Stop

Sequence ID/ Work Center ID Operation Description

Set Up/ **Run Hours**

Tool#

Plan Code

Reject Accept Qty

Qty

Reject Number

Insp. Stamp

130

130

Packaging Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP D412-698-038/ DSI 9484

Location:

PPP rev:_

140

QC21- Final Inspection - Work Order Release

0.00

QC Quality Control

Memo

0.00

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
*								-		
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	Date:		
Resolution:			Dispositi	on:	QA: N/C C	losed:		Date: _		
NCR:	*		WORK ORI	DER NON-CONFORMA	NCE (NC	₹)				
DATE	STEP	Description of NC	4-141-4	Corrective Action Section			ication Approval		Approval	
DAIL	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o		on C	Chief Eng	QC Inspector	
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NOTE: Date & initial all entries

Picklist Print

June-07-12 9:24:11 AM

Work Order ID: 85381

85381

Parent Item:

D412-698-038

D412-698-038

Parent Item Name: Bracket Assembly, RH (Composite Doors)

Start Date: 07/06/2012

Required Date: 21/06/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 11.01.11 new issue DD verified by:EC

IPP Rev:B

11.03.31 AS PER ECN11-531 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3675-6		Manufactured	No			110	Each	4.0000	ا سالسر	1			
D3675-6									**		0.2		10/100

Location	Loc Qty	Loc Code
ST236A	4	
69574	4	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						·			¥		
,]				
Part No:		PAR #:	_ NCR: Yes	No DQA	٨:	_ Date: _	·.				
	Resolution: Disposition: QA: N/C							Date: _			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)					
DATE	STEP	Description of NC Section A	Initial	Action Description	tion B Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector		
			Chief Eng	Chief Eng	Date						
		·									
		4)									
			<u> </u>								

NOTE: Date & initial all entries

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43 REF. FAA STC: SR01446NY REF. EASA.IM.R.S.00709

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the first forward position of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the first forward position of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698

2) Remove the first forward D3199-1 or D3675-1 brackets as applicable.

3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 bracket. Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors).

4) Torque hardware per ICA-D412-698.

5) Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable.

6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

PARTS LIST

QTY -027	QTY. -028	QTY. -037	QTY. -038	PART NUMBER	DESCRIPTION
X				D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	Х			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		Х		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
1				D3199-3	FORWARD BRACKET, LH
	1			D3199-4	FORWARD BRACKET, RH
		1		D3675-5	FORWARD BRACKET, LH
			1	D3675-6	FORWARD BRACKET, RH

WEIGHT AND BALANCE

Installation	Weight	Lateral		Long	itudinal	Applicability	
		Arm	Moment	Arm	Moment	Aphiroapility	
D412-698-027	0.16 lb	-48.0 in	-7.68 in-lb	102.3 in	16.37 in-lb	Aircraft Equipped with	
Bracket Kit	0.07 kg	-1.22 m	-0.09 m-kg	2.60 m	0.18 m-kg		
D412-698-028	0.16 lbs	+48.0	+7.68 in-lb	102.3 in	16.37 in-lb	P/N 205-032-669-XXX	
Bracket Kit	0.07 kg	+1.22 m	+0.09 m-kg	2.60 m	0.18 m-kg	Aluminum Doors	
D412-698-037	0.18 lb	-48.0 in	-8.64 in-lb	102.3 in	18.41 in-lb	Aircraft Equipped with	
Bracket Kit	0.08 kg	-1.22 m	-0.10 m-kg	2.60 m	0.21 m-kg		
D412-698-038	0.18 lb	+48.0 in	+8.64 in-lb	102.3 in	18.41 in-lb	P/N 412-030-300-XXX	
Bracket Kit	0.08 kg	+1.22 m	+0.10 m-kg	2.60 m	0.21 m-kg	Composite Doors	

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01

D. SHEPHERD (DE # 02)

DATE: CERT. NO.: ISSUE NO .:

SH92-43

С	UPDATED -027/-028/-037/-038 KITS AND INSTALLATION	ме	11.03.21
В	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.	МВ	10.12.17
Α	NEW ISSUE	AS	09.10.16
REV.	DESCRIPTION	BY	DATE
DESIG	DART AFROCE		

REV.			DESCRIPTION BY DATE					
DESIGN		8	DART AERO	SPACE I	(D			
DRAWN		A	HAWKESBURY, C	ONTARIO, CANAL	A			
CHECKE	Q	AJS	DRAWING NO.		REV. C			
MFG. API	PR.	N/A	DSI 9484 SHEET 1					
APPROV	ED	NE	TITLE		SCALE			
DE APPR	l	-#-	D412-698-027/-028	/-037/-038 k	Cits мтв			
DATE	11.0	3.21	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONCINCION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OF CONFID ON COMPLEMENTALING THE EXPRESS OWNERS OF THE OWNER PREVIOUS WITHOUT THE PREVIOUS WITH THE PREVIOUS WITHOUT THE PREVIOUS WITH THE PREVIOU					

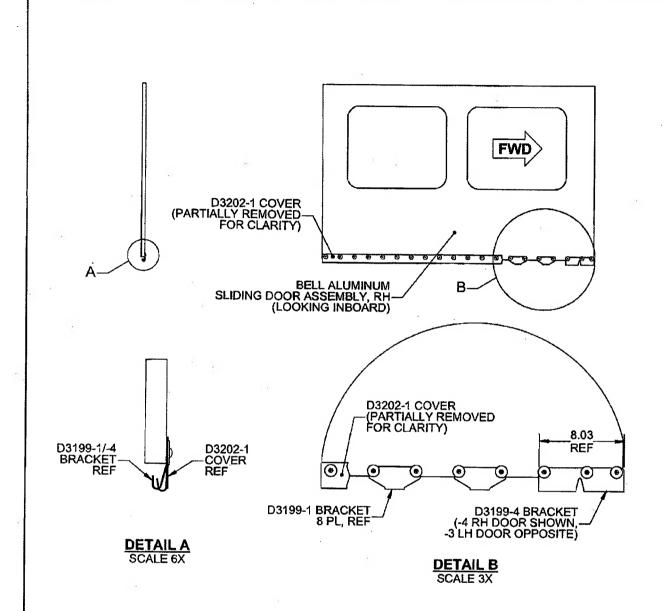
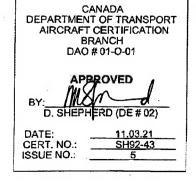


FIGURE 1: D3199-3/-4 BRACKET INSTALLATION ON ALUMINUM DOORS (-4 SHOWN, -3 OPPOSITE)



DESIGN	St.	DART AEROSPACE LTD					
DRAWN	<u> </u>	HAWKESBURY, ONTARIO, CANADA					
CHECKED	AJS	DRAWING NO.	REV. C				
MFG. APPR.	N/An	DSI 9484 _{SHEI}	T 2 OF 3				
APPROVED	M	TITLE	SCALE				
DE APPR.		D412-698-027/-028/-037/-038 Kits	NTS				
DATE 11.0	03.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPERMIAL AND IS SUPPLIED ON THE EXPRESS COMMON THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPER-DIS POINT ABOUTETT TO ANY OTHER DEPOINT OF THE					

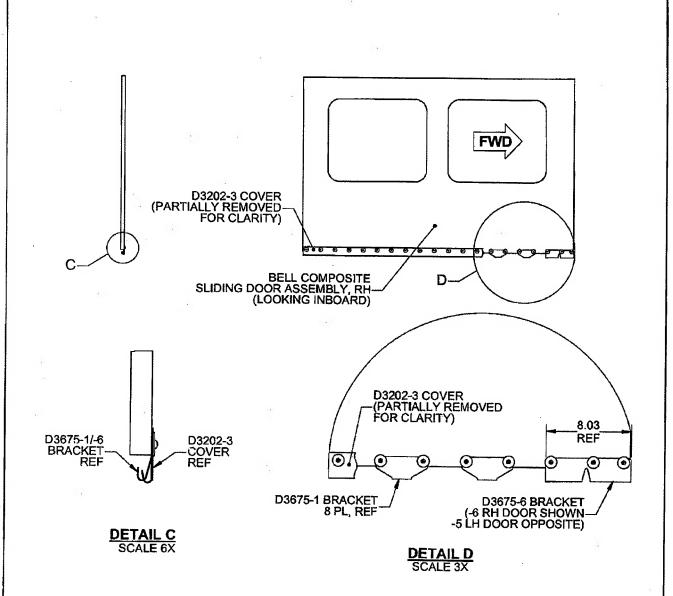


FIGURE 2: D3675-5/-6 BRACKET INSTALLATION ON COMPOSITE DOORS (-6 SHOWN, -5 OPPOSITE)



DESIGN	84	DART AEROSPACE LTD				
DRAWN	13	HAWKESBURY, ONTARIO, CANADA				
CHECKED	ASS	DRAWING NO. REV. C.				
MFG. APPR.	NA	DSI 9484 SHEET 3 OF 3				
APPROVED	100	TITLE SCALE				
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DATE 11.0	3.21	COPYRIGHT @ 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS FROM THE AID CONFEDENTIAL AND BESIDED ON THE EXPRESS CONDITION THAT IT IS NOT TO SE USED FOR MY PURPOSE OR COPED OR COMMENDATED ON THE PERSON WITHOUT WRITTEN PERSON FROM DART AEROSPACE LTD.				

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43 REF. FAA STC: SR01446NY REF, EASA.IM.R.S.00709

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the first forward position of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the first forward position of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors. equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698

2) Remove the first forward D3199-1 or D3675-1 brackets as applicable.

3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 bracket.

Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors). Torque hardware per ICA-D412-698. Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable. Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

PARTS LIST

QTY -027	QTY. -028	-037	QTY. -038	PART NUMBER	DESCRIPTION
X				D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	X			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
1				D3199-3	FORWARD BRACKET, LH
	1			D3199-4	FORWARD BRACKET, RH
	1	1		D3675-5	FORWARD BRACKET, LH
			11	D3675-6 7	FORWARD BRACKET, RH

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal		Applicability	
		Arm	Moment	Arm	Moment	4	
D412-698-027 Bracket Kit	0.16 lb 0.07 kg	-48.0 in -1.22 m	-7.68 in-lb -0.09 m-kg	102.3 in 2.60 m	16.37 in-lb 0.18 m-kg	Aircraft Equipped with P/N 205-032-669-XXX Aluminum Doors	
D412-698-028 Bracket Kit	0.16 lbs 0.07 kg	+48.0 +1.22 m	+7.68 in-lb +0.09 m-kg	102.3 in 2.60 m	16.37 in-lb 0.18 m-kg		
D412-698-037 Bracket Kit	0.18 lb 0.08 kg	-48.0 in -1.22 m	-8.64 in-lb -0.10 m-kg	102.3 in 2.60 m	18.41 in-lb 0.21 m-kg	Aircraft Equipped with P/N 412-030-300-XX Composite Doors	
D412-698-038 Bracket Kit	0.18 lb 0.08 kg	+48.0 in +1.22 m	+8.64 in-lb +0.10 m-kg	102.3 in 2.60 m	18.41 in-lb 0.21 m-kg		

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01

PAROVED

DATE: CERT. NO .: SH92-43 ISSUE NO.:

C	UPDATI	ED -027/-028/-0:	MB	11.03.21			
В	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.			мв	10.12.17		
Α	NEW ISSUE			45	09.10.16		
REV.	DESCRIPTION				DATE		
DESIGN A		4	DART AEROSPACE LTD				
DRAWN		\L_X	HAWKESBURY, ONTARIO, CANADA				
CHECKED		ASS	DRAWING NO.		REV. C		
MFG. APPR.		NA	DSI 9484		SHEET 1 OF 3		
APPRO	VED	M	TITLE		SCALE		
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